

Date: Wednesday, 1/30/2008 7:57:22 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE
Job Number : 37087	
Estimate Number : 10910	
P.O. Number :	Part Number : D33631
This Issue : 1/30/2008 S.O. No. :	Drawing Number : D3363 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : C
Previous Run : 29826	Material :
Written By :	Due Date : 2/11/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JA 08 01 30</u>	
Comment : Est: B 05.09.09 Remove c'sink rivet holes and add welding step KJ/JLM Est: C 06.11.15 waterjet EC	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 2.4150 sf(s)/Unit Total : 9.6600 sf(s)
6061-T6 .063 thick aluminum Sheet
Batch: 105225 LB 8-1-30

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3363
Dwg Rev: C LB 8-1-30
Prog Rev: C

2-Deburr if necessary LB 8-1-30

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
Deburr
Form as per Dwg D3363

SB

08/22/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/05	5	1 part was out of tolerance at the setup	<i>[Signature]</i>	Scrap & destroy No replace 10.02.05	SB 08/02/05	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:57:22 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE

Job Number: 37087

Part Number: D33631

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20802.06 (4)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using DT8790 as per Dwg D3363 and QSI 004

20802.06 (4)
08/02/07

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 08-02-07 (4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/07 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

FF 08-02-07 (4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08 (4)

Job Completion



2008/2/08 (4)
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. C

SHEET 1 OF 3

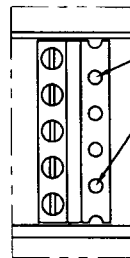
DESIGN	DRAWN BY	DRAWING NO.	TITLE	SCALE
P41	P41	D3363	CONSOLE ASSEMBLY	1:5
CHECKED	APPROVED			
DATE				
07.01.26				

A	04.11.29	NEW ISSUE
B	05.03.28	INCREASE WIDTH BY 0.125
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT

RELEASED

07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL
THROUGH D3363-1 CONSOLE (TYP 4 PLACES)
C'SINK (#0.225 X 100")
FROM TOP SIDE OF CONSOLE



DETAIL C
(SCALE 1:2)

DETAIL C

INSTALL D3361-1 & D3362-1 USING
MS20426AD4-6 RIVETS
(TYP 9 PLACES)

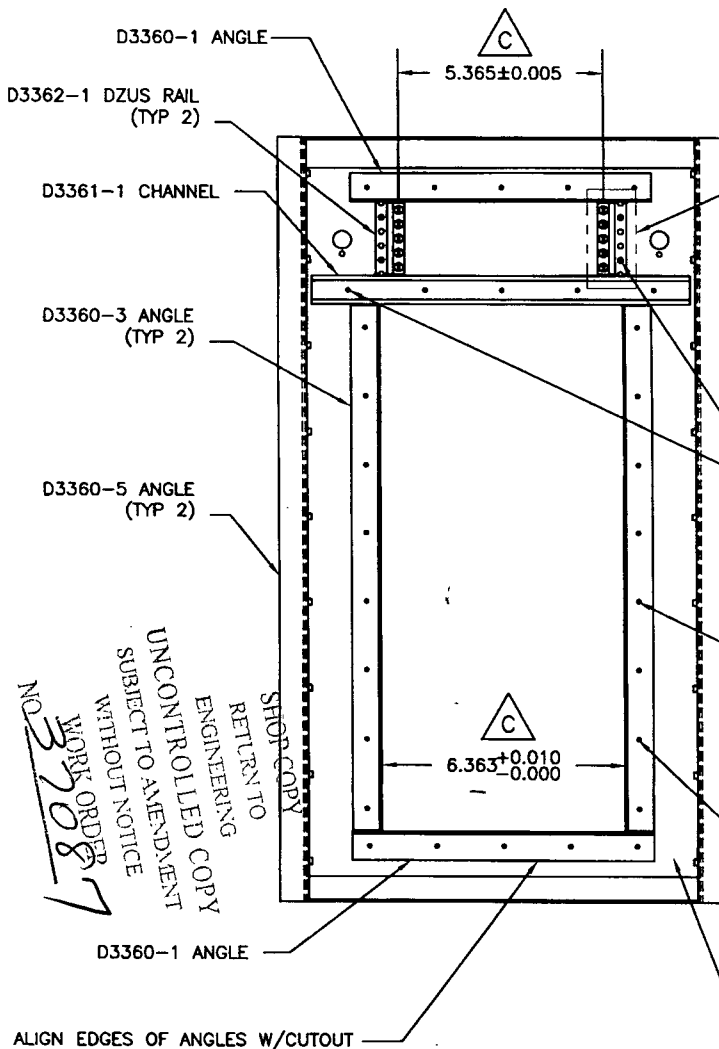
TRANSFER DRILL #30 FROM
MATING PARTS THROUGH #40
HOLES IN D3363-1 CONSOLE
(TYP 49 PLACES) C'SINK
(#0.225 X 100") FROM
CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING
MS20426AD4-5 RIVETS
(TYP 44 PLACES)

D3363-1 CONSOLE

PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET



VIEW A-A FROM UNDER CONSOLE ASSEMBLY

D3363-041 CONSOLE ASSEMBLY

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

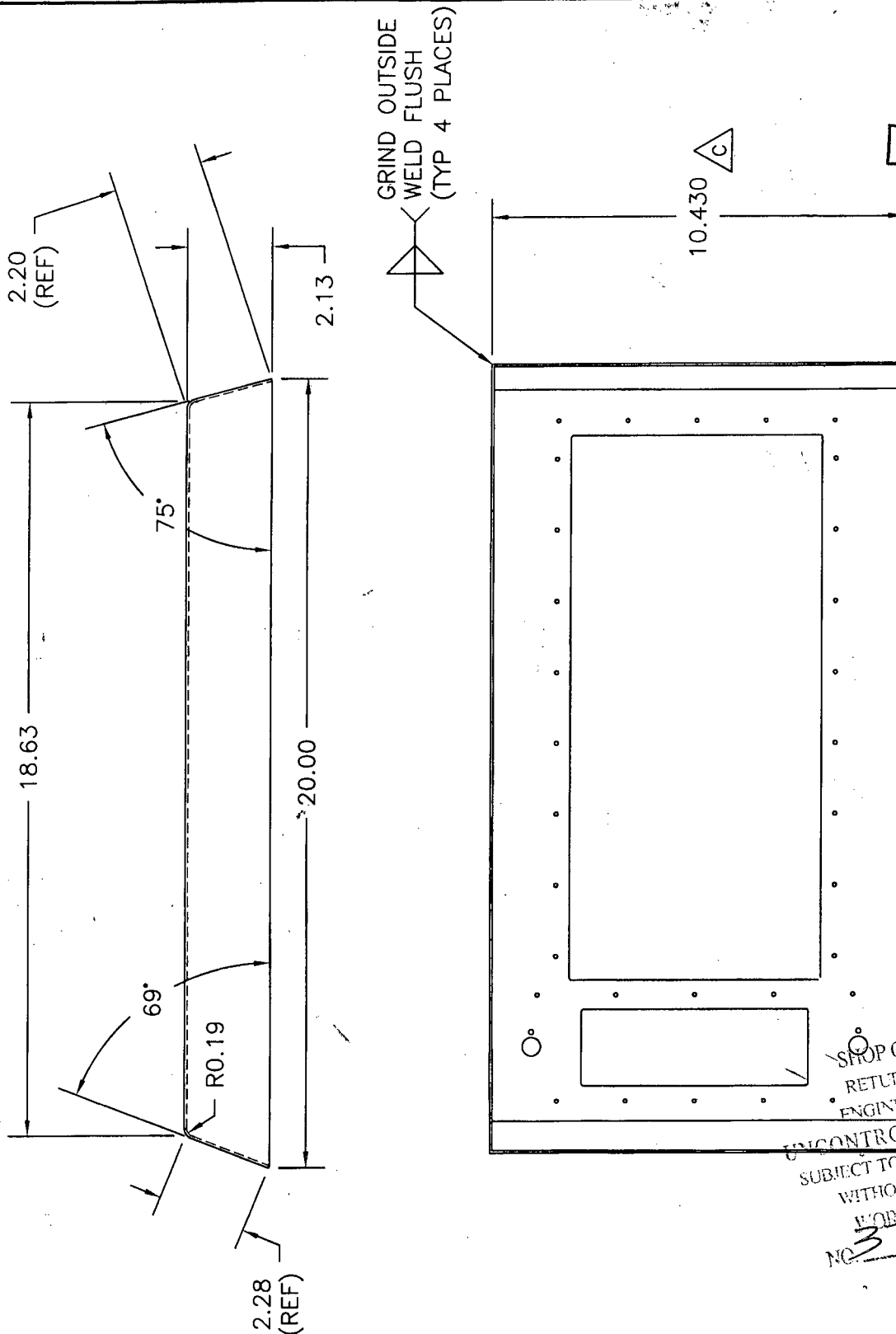
SHOR COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37087

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



RELEASED
07.06.04 *[Signature]*

D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

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D3363-1 CONSOLE

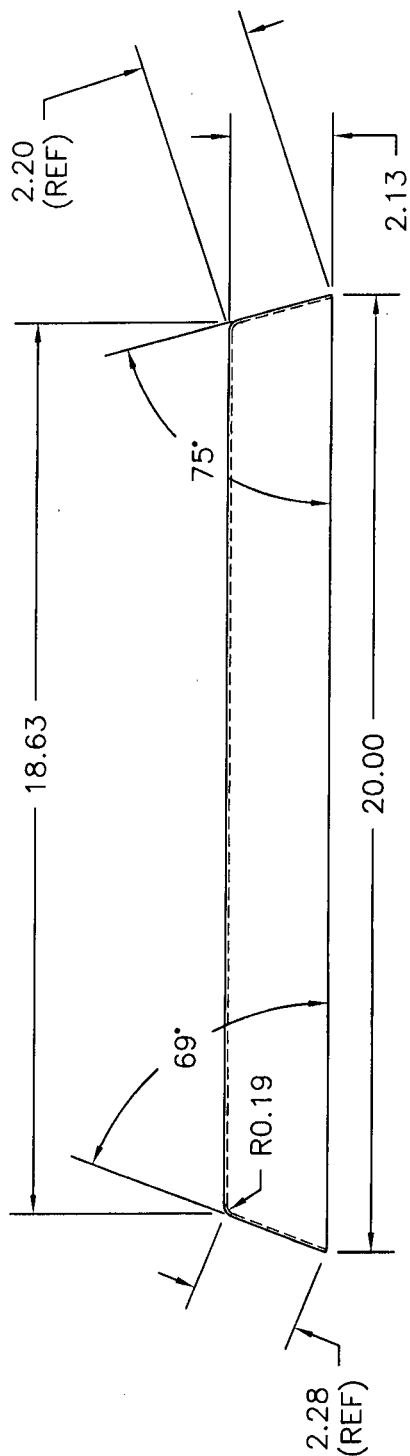
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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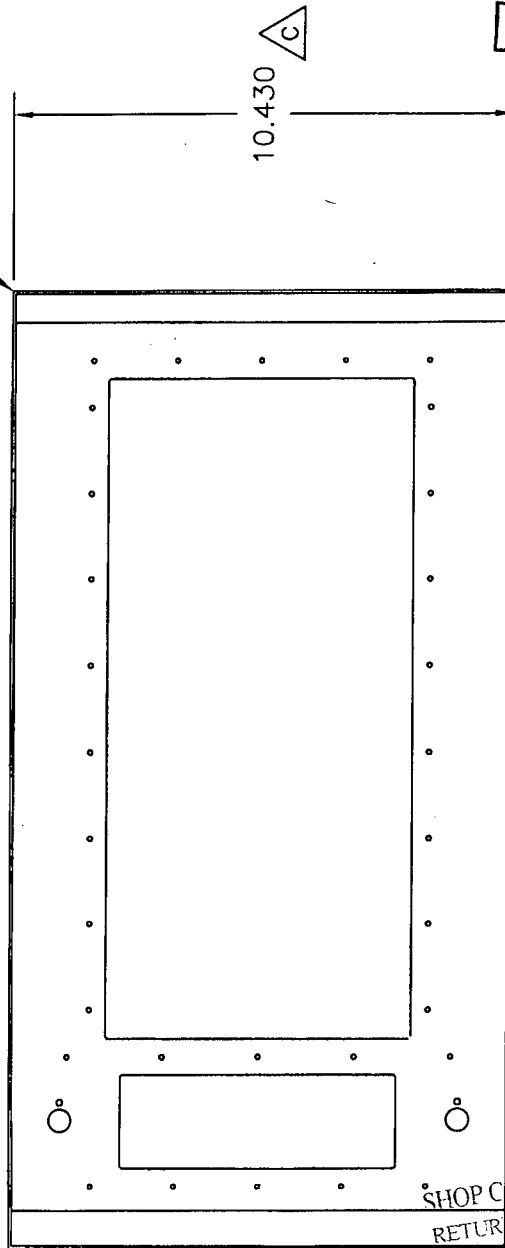
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DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)



RELEASED

07.06.04 *[Signature]*

D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37087

D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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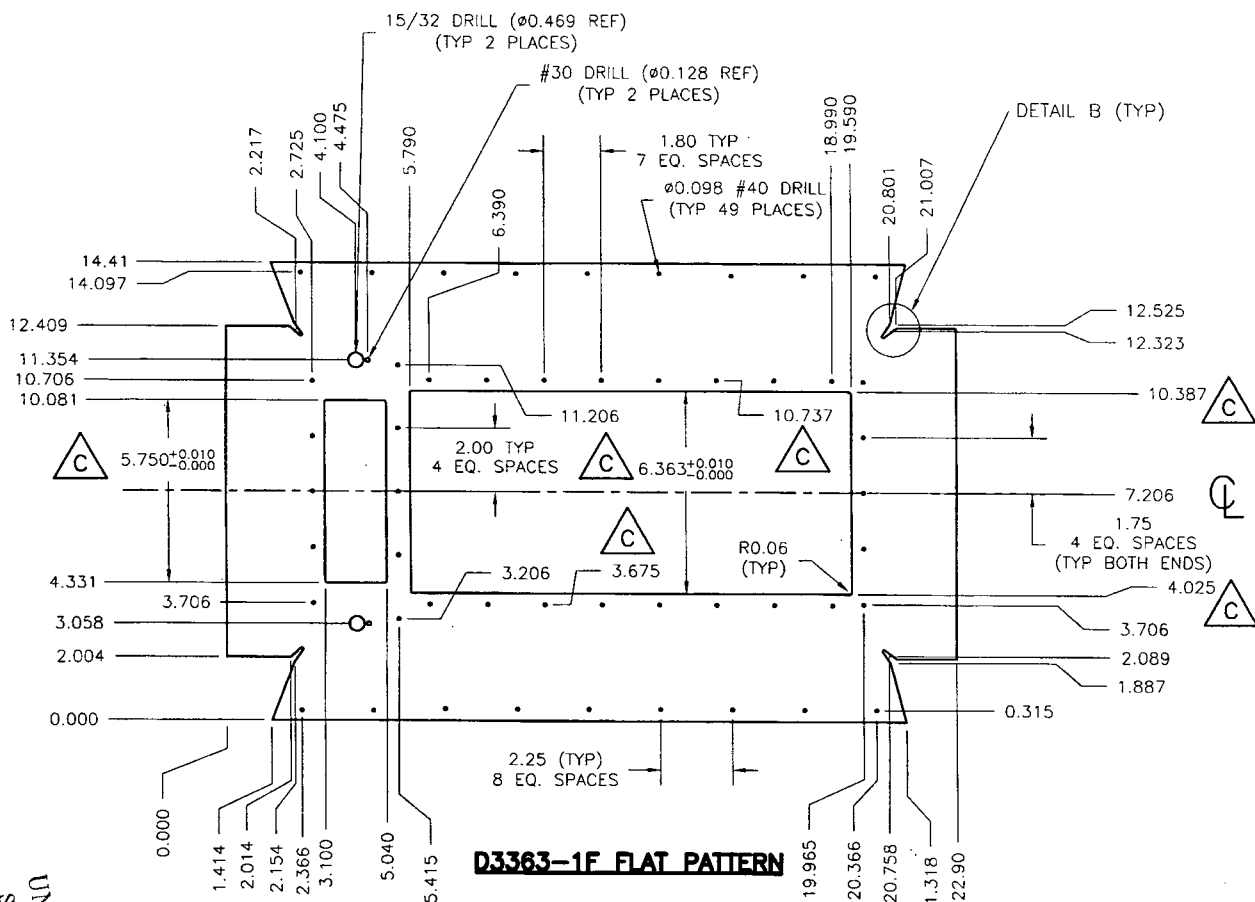
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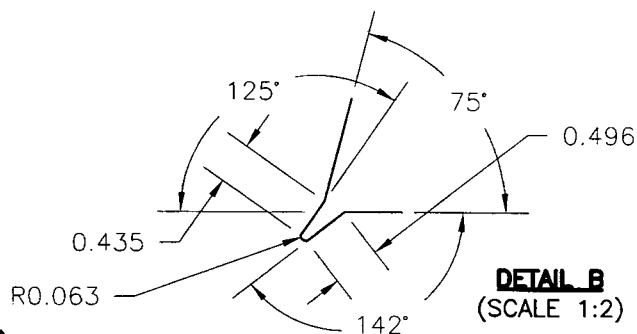
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
GH	GH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 3
GH	GH	D3363	
DATE	TITLE	SCALE	
07.01.26	CONSOLE ASSEMBLY	1:6	

RELEASED

07.06.04



D3363-1F FLAT PATTERN



D3363-1F CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

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DART AEROSPACE LTD		Work Order: 37087
Description: CONSOLE		Part Number: D3363-1
Inspection Dwg: D3363-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒


First Article

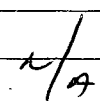
☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	✗			
Ø .128	+ .005 - .001	.131	✗			
Ø .469	+ .006 - .001	.470	✗			
14.41	+/- .030	14.41	✗			
14.097	+/- .010	14.097	✗			
12.409	+/- .010	12.409	✗			
11.354	+/- .010	11.354	✗			
10.706	+/- .010	10.706	✗			
10.081	+/- .010	10.081	✗			
4.331	+/- .010	4.331	✗			
3.706	+/- .010	3.706	✗			
3.058	+/- .010	3.058	✗			
2.004	+/- .010	2.004	✗			
2.366	+/- .010	2.366	✗			
3.100	+/- .010	3.106	✗			
5.040	+/- .010	5.040	✗			
5.415	+/- .010	5.416	✗			
2.25	+/- .030	2.25	✗			
19.965	+/- .010	19.965	✗			
20.366	+/- .010	20.366	✗			
21.318	+/- .010	21.318	✗			
22.90	+/- .030	22.90	✗			
.315	+/- .010	.315	✗			

Measured by: LB
Date: 8-1-30

Audited by: 
Date: 08/01/30

Prototype Approval: 
Date: 8/1/30

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DART AEROSPACE LTD		Work Order:	37087
Description: CONSOLE		Part Number:	D3363-1
Inspection Dwg: D3363-1 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.689	± .010					
3.706	± .010	3.710	X			
4.025	± .010	4.021	X			
7.206	± .010	7.207	X			
1.75	± .030	1.75	X			
10.387	± .010	10.387	X			
12.303	± .010					
19.590	± .010	19.590	X			
18.990	± .010	18.990	X			
1.80	± .030	1.80	X			
6.390	± .010	6.390	X			
5.790	± .010	5.799	X			
4.475	± .010	4.477	X			
4.100	± .010	4.100	X			
2.725	± .010	2.725	X			
2.00	± .030	2.00	X			
6.363	± .010	6.360	X			
10.737	± .010	10.737	X			
11.206	± .010	11.206	X			
3.206	± .010	3.206	X			
3.675	± .010	3.675	X			

Measured by: LB	Audited by: J	Prototype Approval: N
Date: 8-1-30	Date: 08/01/30	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

5

3 → After Assy top rail rework due to rivets/end 7 ~~scrap~~ reworked

At least 4 holes
per part bad c'sink

E